

Work Order ID 84043

84043

Eagle

Page 1

Item ID: D212-725-1-231

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Stiffener Angle

Start Date: 5/1/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/4/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: *MVF*

Date: 12-05-01

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4262

A

100

0.00

100

Small Fab

Memo

0.00

Small Fab

1-Cut as per dwg

2-Make radius as pre dwg and deburr

②

φ

FF

12-05-02

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

②

W

12-05-10

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

②

12-5-11

②

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 84043***84043***

Page 2

Tuesday, May 01, 2012 1:04:05 PM

Item ID: D212-725-1-231

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Stiffener Angle

Stop ***NS2***

Start Date: 5/1/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/4/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

~~QC3- Inspect Part Finish~~

0.00

130

act

QC

Memo

0.00

5/2/05/17

(72)

Quality Control

140

Identify as per dwg & Stock Location: _____

0.00

140

Packaging

Memo

0.00

28

12/5/11

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

NW 12/05/11

Quality Control

ME
12-05-11

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 01, 2012 1:04:04 PM

Page 1

Work Order ID: 84043

Parent Item: D212-725-1-231

Parent Item Name: Stiffener Angle

Start Date: 5/1/2012

Required Date: 5/4/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.10.28 as per dwg revF DD verf:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3A1.0X1.5X125		Purchased	No			100	f	8.0000	1.542	3.2463158			
Angle 2024T3511 1.0x1.50x .125w													

Location

MAT028

116085

1121697

Loc Qty

8

8

Loc Code

1.52315

1.52315

FF 12-05-02

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

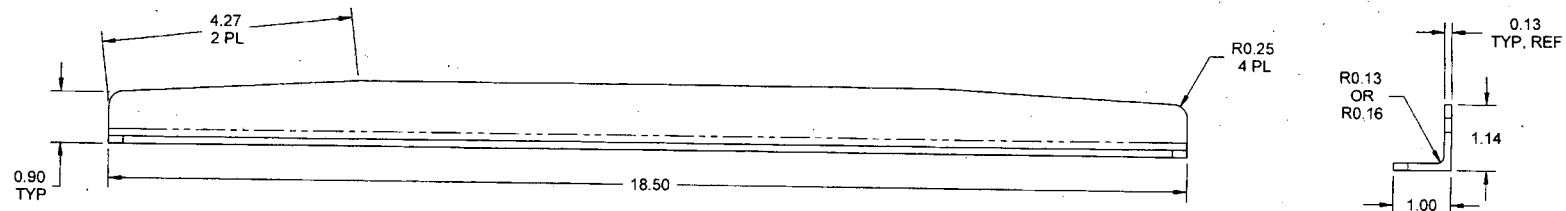
D

C

C

B

B



D212-725-1-231 STIFFENER ANGLE

#84043

RELEASED
2011-08-25
MP

NOTES:

- 1) MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE
PER QQ-A-200/3
OR AMS 4152, 4164 & 4165
PER DART SPEC. M2024T3A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.46 lbs

A NEW ISSUE		RF	11.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4262	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
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8 7 6 5 4 3 2 1

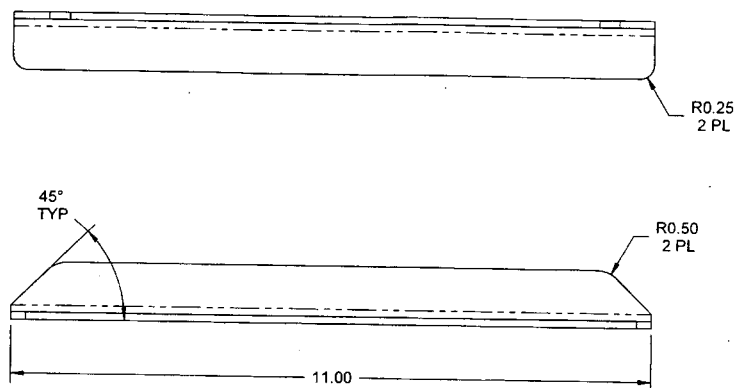
W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D212-725-1-233 STIFFENER ANGLE

NOTES:

- 1) MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE
PER QQ-A-200/3
OR AMS 4152, 4164 & 4165
PER DART SPEC. M2024T3A
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.26 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
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RELEASED
2011-08-25
MD

#84043

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